

Monday, 07/07/2008 8:36:28 AM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BACK LEG		
Job Number	40317			Part Number	D37721		
Estimate Number	13378			Drawing Number	D3772 REVA		
P.O. Number				Project Number	N/A		
This Issue	07/07/2008	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	30/07/2008	Qty:	4 Um: Each
Previous Run							
Written By							
Checked & Approved By	JUL 08. 7.07						
Comment	Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304TR1250W125	304 RD Tube 1.250 x .125w	
		Comment: Qty.: 2.3100 f(s)/Unit Total : 9.2400 f(s) 304 RD Tube 1.250 x .125w BATCH: M 108432	FF 08-07-08
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>(P/D)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3772 2-drill holes thru on both ends of tube as per dwg D3772 3- deburr 4-bend tube as per dwg D3772	{ → FF 08-07-08 { → FF 08-07-10e
3.0	QC5	INSPECT WORK TO CURRENT STEP	 <i>S 08/07/10 x4</i>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	 <i>AS 08/07/10 x4</i>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST266	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: N/A Fault Category: Part has "ass" need small
 D412-769 NCR: Yes No DQA: D Date: 08/07/15
 QA: N/C Closed: D Date: 08/07/15

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/09	# 20	After Drilling Part employer relizes that he had that drilled the far end hole wrong.	PFF 08.07.09 QSI 042	Scrap and Destru and replace BL ^{MWS432} PART IS STRUCTURAL	c8/07/09 FF	C 08/07/09	A 08.07.09 QSI 042	(08/07/09
		R.C. temperature in shop is high and lack of attention.						

NOTE: Date & initial all entries

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5.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/08 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

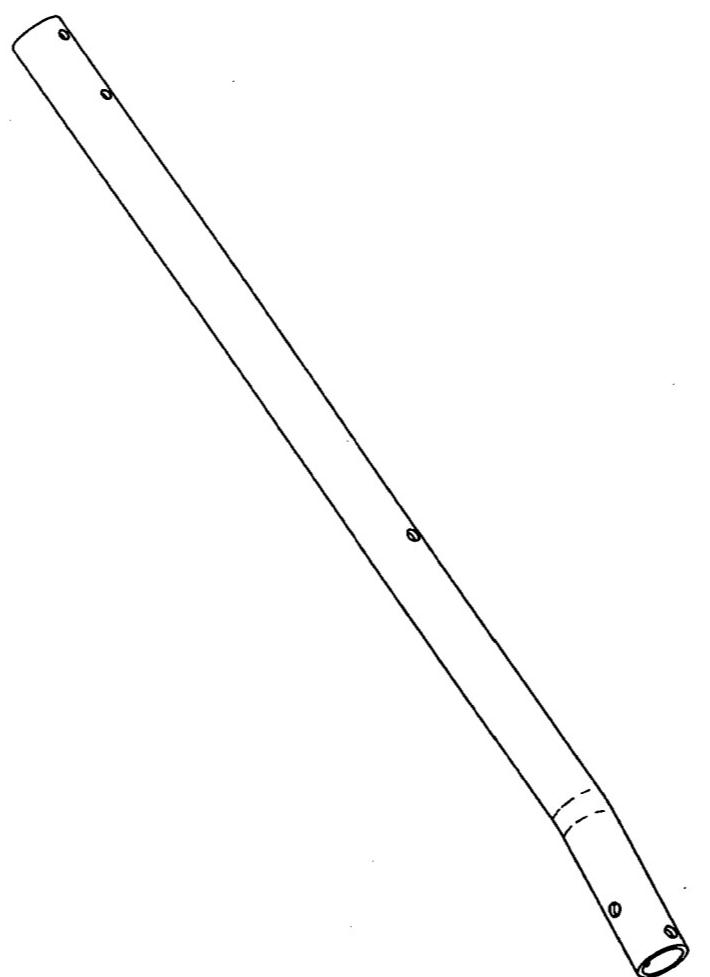
C

B

B

A

A



D3772-1 BACK LEG

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4031

RELEASED
08-06-13 MM

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>MM</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>MM</u>	D3772	SHEET 1 OF 2
APPROVED	<u>MM</u>	TITLE	SCALE
DE APPR.	<u>MM</u>	BACK LEG	NTS
DATE	08.06.03		

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8 7 6 5 4 3 2 1

